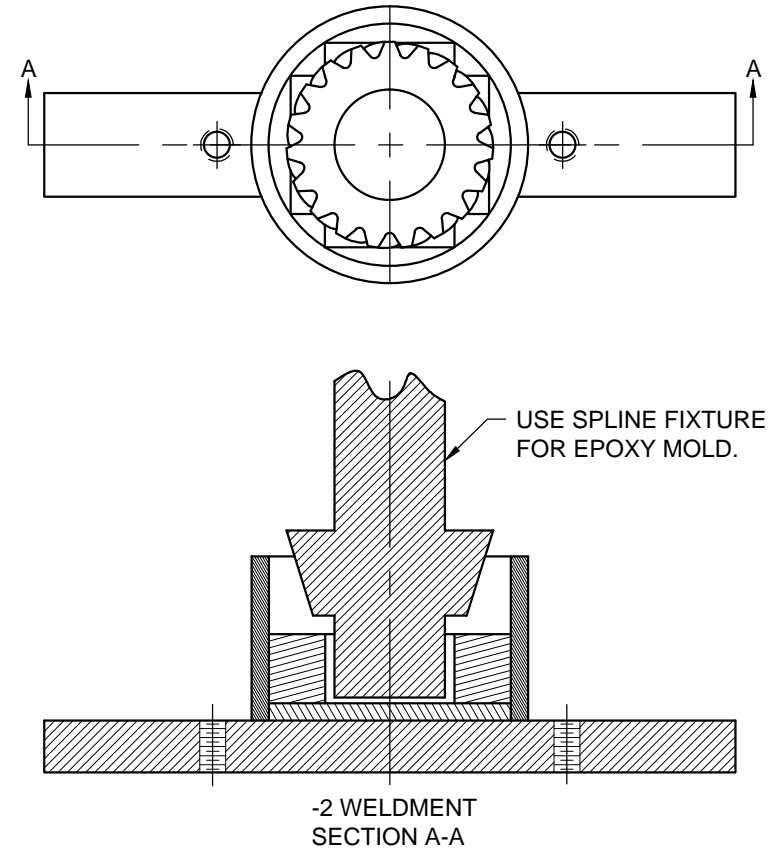


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	IMPLEMENTED NEW FORMAT, ALSO ADDED ASSEMBLY DRAWING AND Pg. 3 EPOXY INSTRUCTIONS.	3/9/09	WP	RW
2	CHANGED PAGE NUMBERS.	5/21/09	RJC	RW

POURING OF EPOXY INTO GEAR POTS

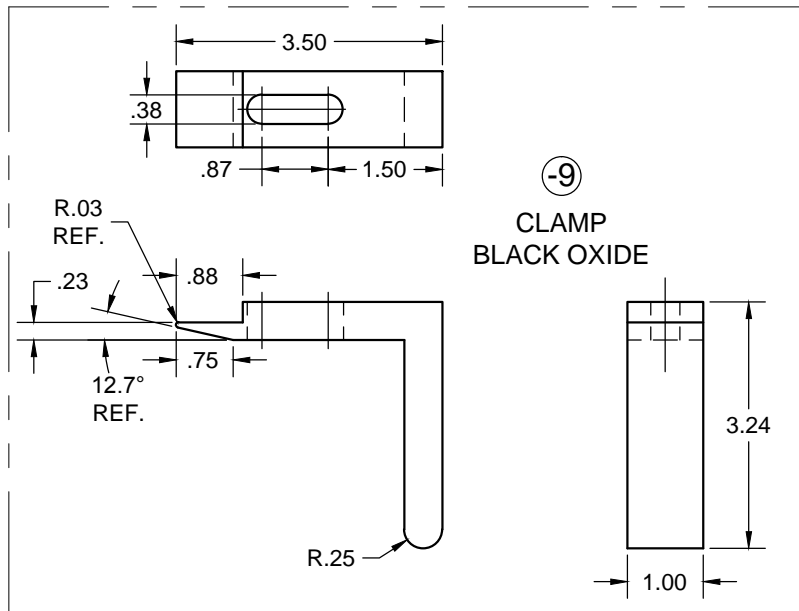
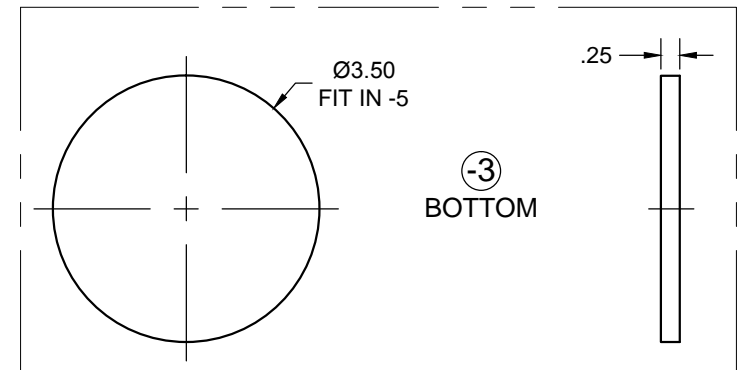
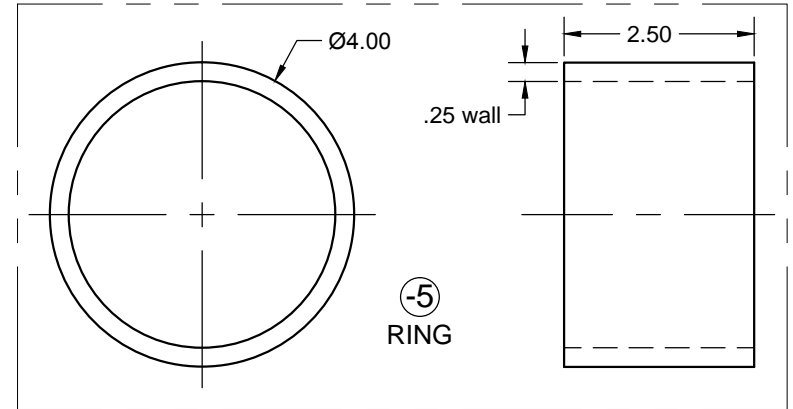
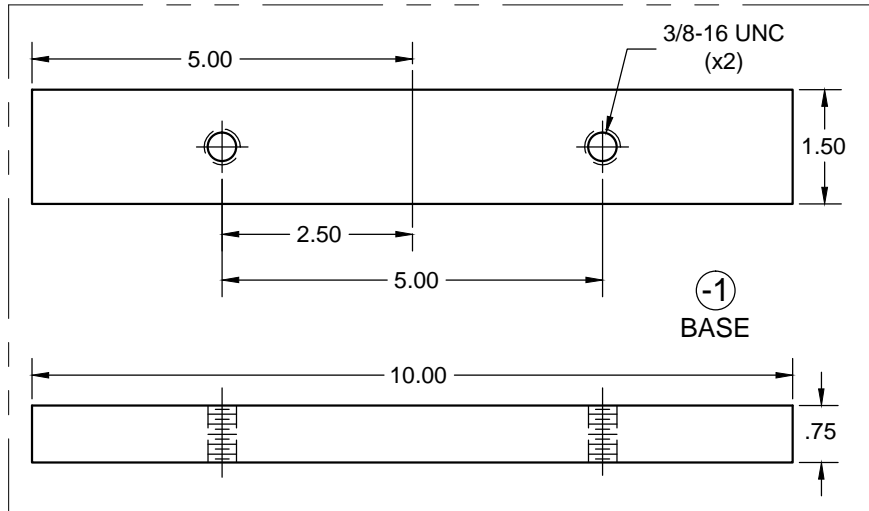
1. BE SURE THAT THE SMALL BLOCKS OF STEEL HAVE BEEN WELDED INTO THE CAVITY, THIS WILL HELP FILL THE CAVITY AND STOP THE ROTATION OF THE GEAR. BE CAREFUL TO ALLOW SPACE FOR THE EPOXY AROUND THE GEAR.
2. THOROUGHLY BEAD BLAST THE INSIDE OF THE CAVITY AND OUTSIDE OF THE HOUSING.
3. PAINT THE OUTSIDE OF THE POT ASSEMBLY WITH FLAT BLACK PAINT.
4. LEVEL THE TOP LIP OF THE CAVITY. IT SHOULD HAVE ALREADY BEEN MACHINED.
5. WET THE GEARED SPLINE WITH DEVCON BRAND RELEASE AGENT ONLY.
6. MIX FLEXANE 94 LIQUID AND THE CATALYST WITH A DRILL MOTOR AND A MIXING BLADE FOR A FULL 2 MINUTES. APPROXIMATELY A HALF CAN OF MIXED COMPOUND IS NEEDED.
7. POUR ENOUGH FLEXANE 94 INTO POT TO FILL ABOUT HALF WAY UP THE SIDE.
8. CAREFULLY PLACE THE GEARED SPLINE INTO THE MIDDLE OF THE POT.
9. CAREFULLY FILL THE POT TO THE TOP OR SLIGHTLY ABOVE, DO NOT GET MATERIAL ON TOP OF THE METAL EDGE OR DOWN THE SIDES OF THE POT.
10. USE A HEAT GUN TO BURST ALL THE BUBBLES THAT COME TO THE TOP OF THE POURED MIXTURE.
11. AFTER THE FLEXANE 94 HAS SETUP ABOUT 10 MINUTES CAREFULLY BREAK THE GEARED SPLINE LOOSE.
12. LEAVE THE GEARED SPLINE IN PLACE UNTIL THE FLEXANE HAS SET UP COMPLETELY, ABOUT 1 HOUR.
13. PREPARE EXTRA POTS AND POUR WITH EXCESS MATERIAL. DO NOT MAKE PARTIAL POURS OF FLEXANE 94 INTO POTS.



RED BARN MACHINE	
TITLE D MODEL INPUT GEAR HOLDING FIXTURE; EPOXY MIXING INSTRUCTIONS	
DWG NO. RBD25121-30201	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC SEE PARTS & WELDMENT USED ON MODEL MD 500
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE NTS DATE 11-30-06 SHEET 3 of 3

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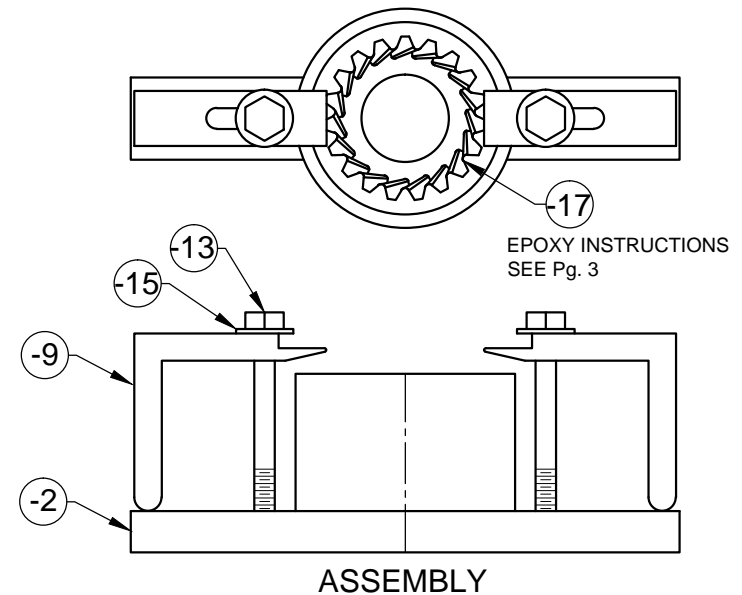
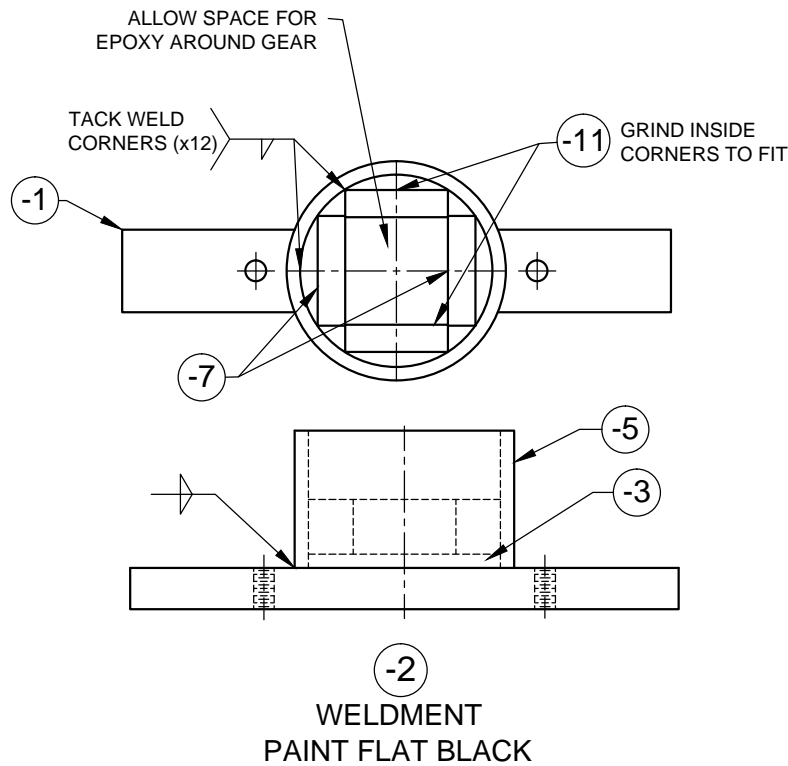
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CHANGED PAGE NUMBERS.	5/21/09	RJC	RW
3	ADDED NOTCH CUT OUT IN -9 CLAMP TO ALLOW PART IN-BETWEEN GEAR AND BEARING. ALSO SHORTENED -5 RING FROM 2.75 TO 2.50 LENGTH TO KEEP CLAMP FROM TOUCHING.	12/10/09	WP	



RED BARN MACHINE	
TITLE D MODEL INPUT GEAR HOLDING FIXTURE; PARTS	
DWG NO. RBD25121-30201-1 thru -9	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC SEE PARTS & WELDMENT USED ON MODEL MD 500
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-30-06 SHEET 2 of 3

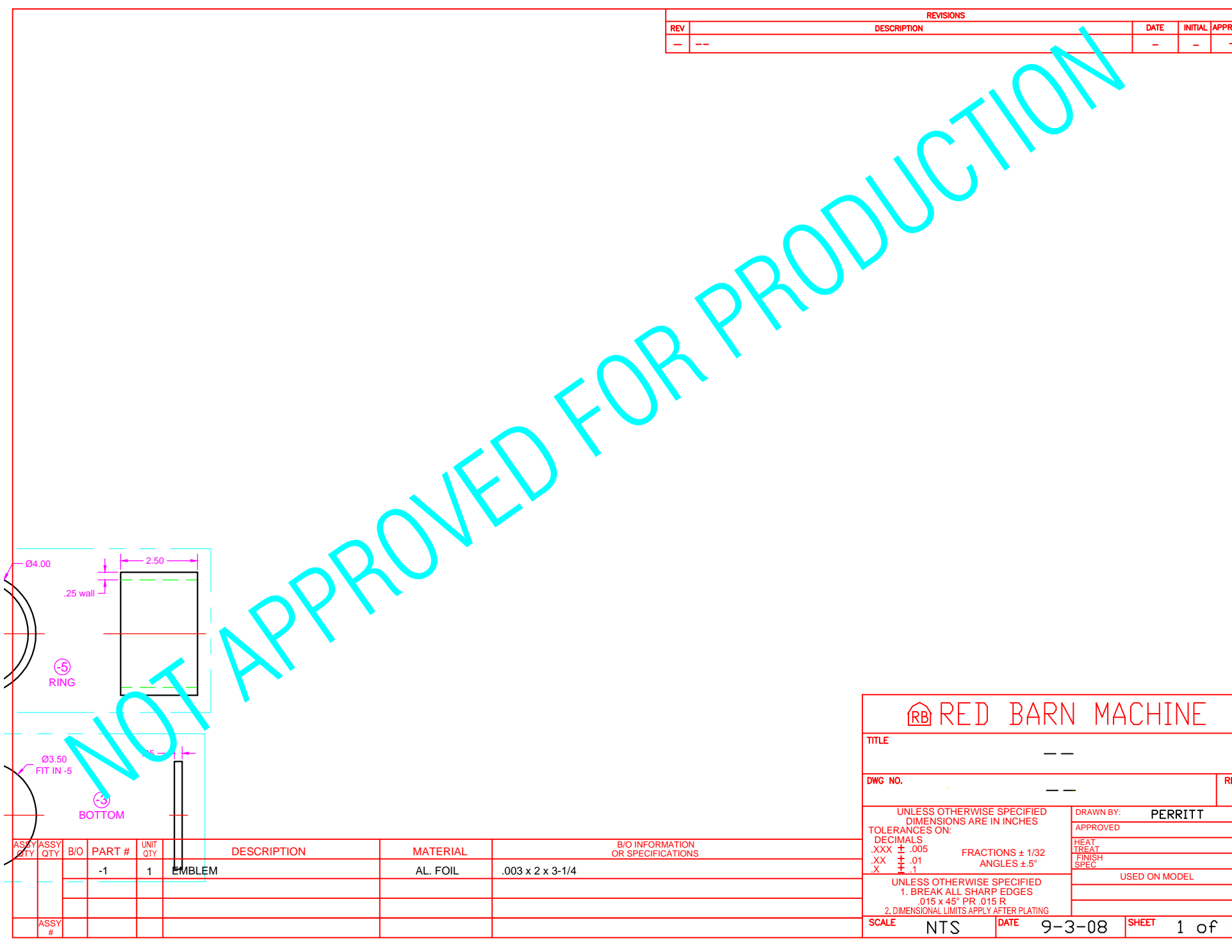
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	IMPLEMENTED NEW FORMAT, ALSO ADDED ASSEMBLY DRAWING AND Pg. 3 EPOXY INSTRUCTIONS.	3/9/09	WP	RW
2	CHANGED PAGE NUMBERS.	5/21/09	RJC	RW
3	ADDED NOTCH CUT OUT IN -9 CLAMP TO ALLOW PART IN-BETWEEN GEAR AND BEARING. ALSO SHORTENED -5 RING FROM 2.75 TO 2.50 LENGTH TO KEEP CLAMP FROM TOUCHING. ALL REV 3 CHANGES PER DW	12/10/09	WP	



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		BASE	1018 FLAT BAR	3/4 x 1-1/2 x 10	2
	1		-2	1	WELDMNT		-1 & -3 & -5 & -7 & -11	1
	1		-3		BOTTOM	1018 RND. BAR	Ø3-1/2 x 1/4	2
	1		-5		RING	DOM	Ø4 x 1/4 wall x 2-3/4	2
	2		-7		SIDE STIFFENER	1018 FLAT BAR	1/2 x 1 x 2	2
	2		-9	2	CLAMP	ANGLE, STRUCTURAL	1/2 x 3-1/2 x 3-1/2 x 1-1/8 long	2
	2		-11		STIFFENER	1018 FLAT BAR	1/2 x 1 x 1-7/8	2
		B/O	-13	2	HEX HEAD CAP SCREW	GR. 5; PLATED	3/8-16 UNC x 4	1
		B/O	-15	2	FLAT WASHER	PLATED STEEL	Ø3/8	1
		B/O	-17	1	EPOXY	DEVCON FLAXANE 94	1/2 CAN OF MIXED COMPOUND APPLIED #15250	3
		B/O	-19	1	RELEASE AGENT	DEVCON	APPLIED #19600	3

RED BARN MACHINE			
TITLE			
D MODEL INPUT GEAR HOLDING FIXTURE			
DWG NO. RBD25121-30201			REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS .XXX ± .005		HEAT TREAT	
XX ± .01		FINISH SPEC SEE PARTS & WELDMNT	
X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		MD 500	
SCALE NTS	DATE 11-30-06	SHEET 1 of 3	

[illegible][illegible]

						REVISIONS		
REV	DESCRIPTION					DATE	INITIAL	APPR
-	--					-	-	-

The technical drawing shows two views of a rectangular emblem. The top view has a width of 2.50 inches and a height of .25 inches, labeled as '.25 wall'. A circular feature with a diameter of Ø4.00 is shown to the left, labeled '(5) RING'. The bottom view shows a similar rectangle with a width of 2.50 inches and a height of .15 inches, labeled as 'BOTTOM'. A circular feature with a diameter of Ø3.50 is shown to the left, labeled 'FIT IN -5'.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	EMBLEM	AL. FOIL	.003 x 2 x 3-1/4
	ASSY #						

TITLE RED BARN MACHINE			
DWG NO. -- --			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS .XXX ± .005		HEAT TREAT	
XX ± .01		FINISH	
X ± .1		SPEC	
FRACTIONS ± 1/32		USED ON MODEL	
ANGLES ± 5°			
UNLESS OTHERWISE SPECIFIED			
1. BREAK ALL SHARP EDGES			
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 9-3-08	SHEET 1 of	


NOT APPROVED FOR PRODUCTION

NOT APPROVED FOR PRODUCTION

NOT APPROVED FOR PRODUCTION

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVE
--	--	-	-	-

ASSY QTY	ASSY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	EMBLEM	AL. FOIL	.003 x 2 x 3-1/4
ASSY #							

 RED BARN MACHINE	
TITLE --	
DWG NO. --	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-3-08
SHEET 1 of 1	

DRAWN BY: PERRITT

APPROVED

HEAT TREAT

FINISH SPEC

USED ON MODEL